

Del R 1.000"

Work Order ID 77568

77568

Page 1

December-13-11 1:52:19 PM

Item ID: D3455-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spacer

Start Date: 13/12/2011 Start Qty: 40.00

40

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 11/12/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3455

Rev A

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

HARDHINGE COBRA1-TURN AS PER FOLIO FA583 & DWG D3455
FOLIO REV: AA DWG REV: A 2-DEBURR AS REQUIRED

40

0

28 SS 12/01/16

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

40

0

28 SS 12/01/16

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

B.A 12/01/16

40

0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77568***77568***

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December-13-11 1:52:19 PM

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary.								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: ST 44								
Packaging	Memo	0.00							
Packaging									

SP 12-01-18.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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2018
(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-13-11 1:52:23 PM

Page 1

Work Order ID: 77568

77568

Parent Item: D3455-1

D3455-1

Parent Item Name: Spacer

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MDELRINR1.000		Purchased	No			100	f	65.3995	0.022	0.926316			
---------------	--	-----------	----	--	--	-----	---	---------	-------	----------	--	--	--

MDFI RINR1 000

0.610'

SI 12-01-14

Delrin Round Bar 1"

Location

Loc Qty

Loc Code

MAT055

65.3995

117985

0.407

118257

6.502

118392

10.4905

119306

48

0.610'

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3455	REV. A SHEET 1 OF 1
DATE 05.09.02		TITLE SPACER	SCALE 2:1
A	05.09.02	NEW ISSUE	

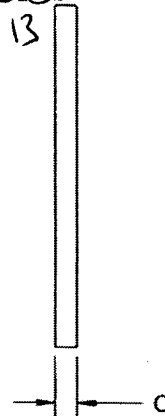
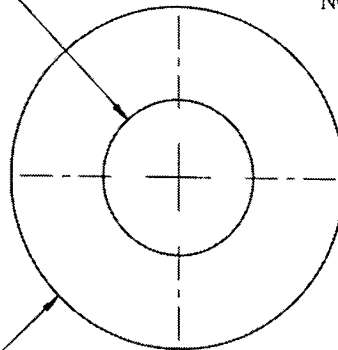
RELEASED

05.12.09 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **77568 H.L.J**
11/12/13

ϕA $\begin{matrix} +0.005 \\ -0.000 \end{matrix}$

ϕB



D3455-X

1) SPECIFICATION: **D3455-X SPACER**

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)
-1	0.453	1.00	0.065
-3	0.386	1.00	0.050

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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